

Date: Thursday, 02/11/2006 3:27:16 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 29256
 Estimate Number : 10804
 P.O. Number : N/A
 This Issue : 02/11/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 00015
 Written By :
 Checked & Approved By :
 Comment :

Drawing Name : D206667101
 Part Number : D206667101
 Drawing Number : CHG 002
 Project Number : N/A
 Drawing Revision : N/A
 Material : N/A
 Due Date : 10/11/2006

Qty: 1 Um: Each

Additional Product

DART		TEL: 1-613-632-3335 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL #09-89			
P/N	D206-667-101	CHG	CHG001
DESC.	Crosstube Fwd High	STC	SH01-5
LOT	B17026	STC	SR01304NY
MODEL	206A/B	STC	
MADE IN CANADA			

Job Number:



Seq. #: Machine Or Operation:

1.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
 BUFF CUFFS, DRILL OEM HOLES PER CHG 002

ST 06-11-08

2.0 D206667101 Crosstube Installation



* Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Crosstube Installation
 B 17026

ST 06-11-08

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-11-20

4.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING
 MASK AND
 RE-PRIME & REPAINT CUFFS

ML 06 11 22

①

5.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

11/06/11/23 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/11/2006 3:27:17 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206667101

Job Number: 29256

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2873043

Nut Plate Assembly



*** Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-043

Nut Plate

B28075

RT

06-11-08

7.0

D2873045

Nut Plate Assembly



*** Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-045

Nut Plate

28076

RT

06-11-08

8.0

MS20601AD4W8



*** Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number

Description Batch

14 MS20601AD4W8

Rivet

M100771

RT

06-11-08

9.0

QC5

INSPECT WORK TO CURRENT STEP



JOB 11-20-08
Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP

11.0

AN57A

Bolt



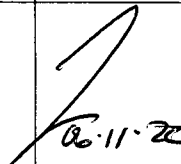
RT
Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)


Bolt

M102140

PB 06/11/07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-11-20	8.1	Install nut plates; rivets as per Dwg.	KE	06-11-21	1		 06-11-20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/11/20
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/11/2006 3:27:17 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206667101

Job Number: 29256

Part Number: D206667101

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 AN530A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
BOLT M102473

1/11

already in kit

CHG 002

13.0 AN960JD516 Washer



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)
Washer M100564

N/A

1/18

BS 06/11/27

1/18

①

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

BS 06/11/28

Job Completion



12/06/11/28

Need to be added to computer system

13 Add to kit per CHG 002

add to kit
PN M 5399 ← *4x AN S-32A M102520x2, M114781x2* *BS 06/11/27*
BS-P M10538-21 ← *4x MS21042L5 M102171* *BS 06/11/27*
BS 06/11/27 M5515 ← *8x AN960 JD516 M100564* *BS 06/11/27*

13b Inspect kit 1/4/11/27 ①

13c Repackage per APP using new kit (CHG 002)

New paperwork + labels req'd

BS 06/11/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-141	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 H**UNDER REVIEW**
06.08.10 AH
re.dwn detail F

Qty	Part Number	Description
X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

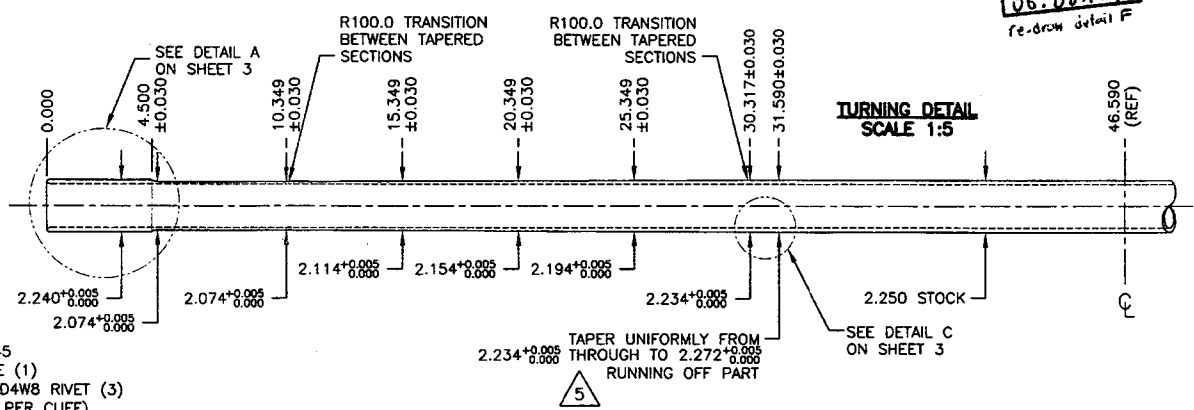
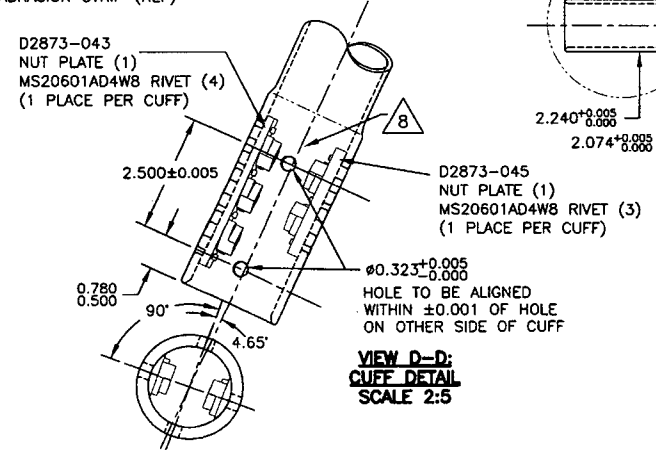
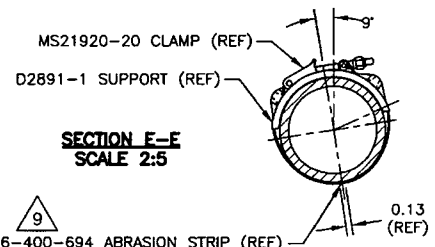
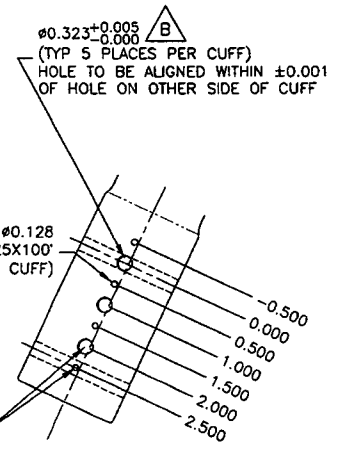
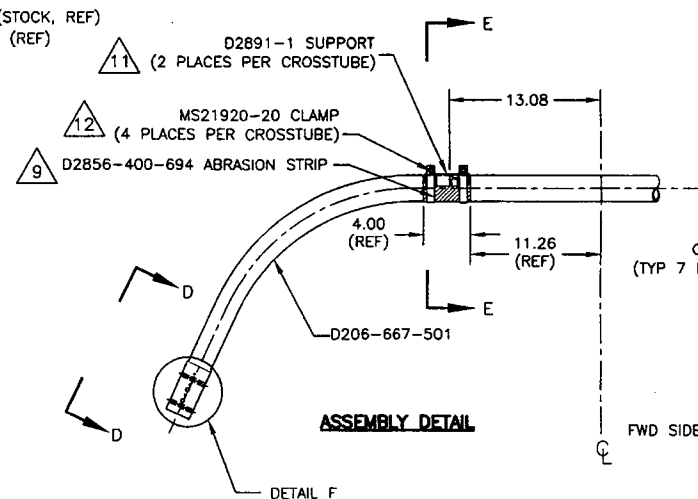
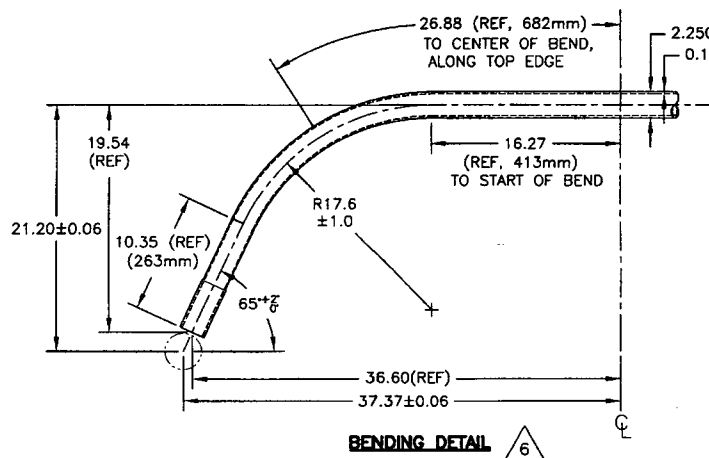
REFERENCE ONLY

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

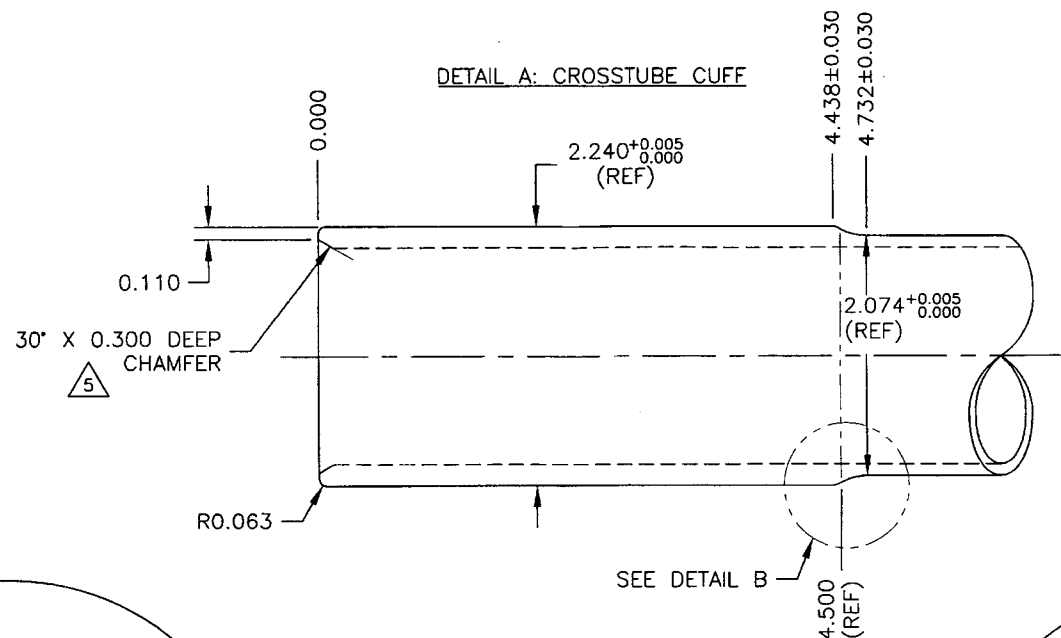
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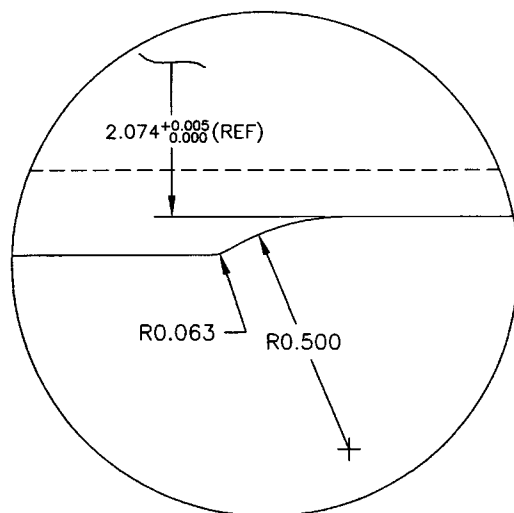
UNDER REVIEW
06.08.10 PH
re-draw detail F

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA	REV. B SHEET 2 OF 3
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED PH	APPROVED PH		
DATE 05.07.26		DRAWING NO. D206-667-141		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)	SCALE 1:10

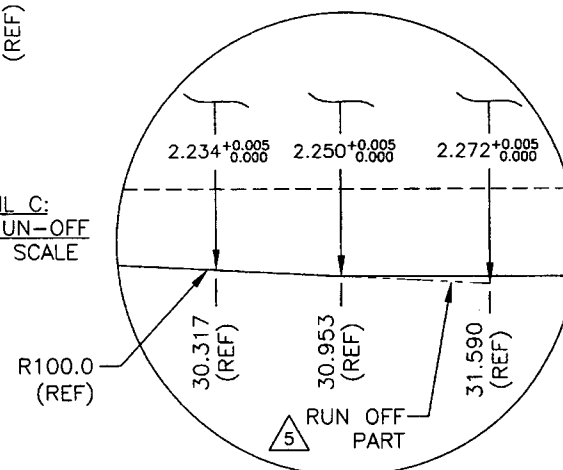


UNDER REVIEW
06.08.10 PH
re-draw detail F

05.07.26



DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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HAWKESBURY, ONTARIO, CANADA

CHECKED

PH

APPROVED

DRAWING NO.
D206-667-141

REV. B
SHEET 3 OF 3

DATE

05.07.26

TITLE

CROSSTUBE ASS'Y (206B HIGH FWD)

SCALE

1:1

ANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill all (3) top holes.

2-Drill & ream holes as per Dwg D206-667-141 using drill Jig DT8575 & DT8576. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill only the top (2) holes.

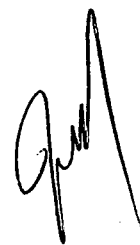
5-Drill pilot holes as per Dwg D206-667-141. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-141.
Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-141. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141

A handwritten signature in black ink, consisting of a stylized 'G' followed by a vertical line and a small flourish.

5.0 PARTS LIST

Item	Qty -011	Qty -013	Qty -015	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X									D206-667-011	SPACER BLOCK KIT
		X								D206-667-013	NUT PLATE KIT (-101/-103/-105/-203/-205)
			X							D206-667-015	NUT PLATE KIT (-201)
				X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
					X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
						X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
							X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
								X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
									X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1				1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2					1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3						1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4							1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5								1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6									1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10				*2	*2	*2		*2		D2891-1	SUPPORT
11							*2			D2892-1	SUPPORT
12									*1	D2894-1	SUPPORT
13				*2	*2	*2		*2		D2856-400-694	ABRASION STRIP
14							*2		*2	D2856-400-773	ABRASION STRIP
15									*1	D2856-600-851	ABRASION STRIP
16				*4	*4	*4		*4		MS21920-20	CLAMP
17							*4		*4	MS21920-22	CLAMP
18									*2	MS21920-24	CLAMP
19				4	4	4		4		AN5-32A	BOLT
20							4		4	AN5-34A	BOLT
21				4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22				8	8	8	8	8	8	AN960JD516	WASHER
23									*2	D3190-1	CHAFING SHIELD
30	8									AN4-6A	BOLT
31	8									AN4-7A	BOLT
32	16									AN960JD416	WASHER
33	2									D3193-041	SPACER BLOCK ASSEMBLY
40		2		*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41		2		*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42			2		2					D2872-043	NUT PLATE
43			2		2					D2872-045	NUT PLATE
44		10		10		10				AN5-7A	BOLT
45		10	10		10		10	10	10	AN5-10A	BOLT
46		4	4	4	10	4		4		AN5-30A	BOLT
47		4					4		4	AN5-32A	BOLT
48		18	18	10	12	10	10	10	10	AN960JD516	WASHER
49		4	4		6					MS21042L5	NUT (OR MS21042-5)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE